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D2432**Job Sheet 190169****Part No:** D2432**Job Qty:** 12 pcs**Part Name:** Bearpaw 19" X 24"**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/5/19**Job Tracking No:****Due Date:** 3/7/19**Created By:** Jesse White**Type:** Stock**Description:****Note:** DWG REV H IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Waterjet - Omax - 1	12 pcs	3/7/19	3/7/19	0.00	3.09	Waterjet - Omax		bc 19/01/22
130	HAAS 4 Axis - B4B	12 pcs	3/7/19	3/7/19	0.36	15.02	HAAS - 1 - B4B		JTP 19-03-15
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
140	QC 2	12 pcs	3/7/19	3/7/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51	DAS	
							QC 2 - 52	52	19/03/13 JTP 19-03-15
							QC 2 - 54	9-89	
							QC 2 - 56		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

150	QC 8	12 pcs	3/7/19	0.00	0.00	QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 8 - 12	mk 19/03/17
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 38	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
160	Packaging 3-1 - Stock - B4B	12 pcs	3/7/19	0.00	0.00	Packaging 3 - 1 - B4B	5744580, MAR 18 2019
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Other/Details:					

				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170	QC 21 - SA	12 pcs	3/7/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAG

21

9-09

MAR 18 2019

Part Op 120 - Waterjet 2 OMAX (Waterjet 2) Cut Blank as per D2432 File

Descriptions: 130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Debur

140 - (QC2- Inspect parts off machine FAI/FAIB)

150 - (QC8- Inspect parts - second check)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	44.4000 sf (3.7 ea)	120-Waterjet - Omax - 1	5143330

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Waterjet - Omax - 1	MUHMWB10	44	539	0

Part Specifications

Specifications could not be found.

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Date : _____		MRB (QSI042)			
De: _____					
Dart Aerospace Ltd. 1270 Aberdeen Street New Tecumseth, ON K6A 1K7 CANADA TEL: 1-813-632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 02/11/19 Container No: S152315 Part: D2432 Job No: 190169 Serial No/Batch: S152315 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 02/11/19					

DART AEROSPACE LTD		Work Order:	
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: H		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063x45	✓		Ver	
B	0.200	+/-0.030	0.200	✓		D.G.	
C	0.25 x 45°	+/-0.030	0.25x45°	✓		TAPE	
D	R0.250	+/-0.030	R. 0.250	✓		R.G.	
E	0.250	+/-0.010	0.255	✓		Ver	
F	0.625	+/-0.030	0.625	✓		Ver	
G	0.375	+0.030/-0.010	0.390	✓		Ver	
H	0.950	+/-0.030	0.960	✓		Ver	
I	19.000	+/-0.030	19.000	✓		TAPE	
J	Ø0.260	+0.005/-0.000	Ø 0.260	✓		G.P.	
K	Ø0.93	+/-0.030	Ø 0.930	✓		Ver	
L	0.30	+0.030/-0.000	0.315	✓		D.G.	
M	23.750	+/-0.030	23.750	✓		TAPE	
N	2.000	+/-0.030	2.000	✓		Ver	
O	0.38	+/-0.030	0.38	✓		Ver	
P							
Q							
R							
S							
T							
U							
V							

Measured by: DAS 52	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 17/03/13	Date: 19/03/17	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	<i>[Signature]</i>